

Work Order ID 86347

June-27-12 3:20:44 PM

86.347

Page 1

Item ID: D3948-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate, Anchor

Start Date: 27/06/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/28 Tooling:

Date:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3948

B

100

0.00

100

Waterjet

Memo

0.00

12 0 Jm 12-6-28

FLOW CNC Waterjet

1-Cut as per Dwg D3948-1

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12 0 Jm 12-6-28

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

June-27-12 3:20:44 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 27/06/2012 **Start Qty:** 12.00

12

Cust Item ID:

Required Date: 11/07/2012 **Req'd Qty:** 12.00

12

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run	Start	*NR1*
	Stop	*NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

0.00

0.00

0.00

0.00

130

130

Small Fab

Small Fab

Memo

1- countersink holes as per dwg

2- deburr if necessary

QC5- Inspect part completeness to step on W/O

140

140

OC

Memo

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 Chemical Conversion Coat per QSI005 4.1 0.00

150

HandFinish

Memo

0.00

Hand Finishing

12/12/05

160 QC3- Inspect Part Finish 0.00

160

QC

Memo

0.00

Quality Control

12/07/05

170 Pick Kit 0.00

170

Packaging

Memo

0.00

Packaging

12/07/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 86347

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Page 4

June-27-12 3:20:44 PM

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Stop ***NS2***

Start Date: 27/06/2012 Start Qty: 12.00

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Cust Item ID:

Required Date: 11/07/2012 Req'd Qty: 12.00

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Customer:

Reference:

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Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

0.00

180

Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

12x

[Signature]
12/07/12

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

DAS
16
2-53 12/07/12

(12)

200

Identify as per dwg & Stock Location: *877*

0.00

200

Packaging

Memo

0.00

Packaging

12x

SD
12-7-12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
		Q4 +1 Part Found to have A						

NOTE: Date & initial all entries

Work Order ID 86347***86347***

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June-27-12 3:20:44 PM

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

MLJ 12/07/25

MLP
12-07-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-27-12 3:20:48 PM

Page 1

Work Order ID: 86347

86347

Parent Item: D3948-041

D3948-041

Parent Item Name: Plate, Anchor

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063		Purchased	No			100	sf	514.0368	0.1085	1.370526			
--------------	--	-----------	----	--	--	-----	----	----------	--------	----------	--	--	--

M6061T6S 063

6061-T6 .063 Sheet

**

Jm 12-6-28

Location	Loc Qty	Loc Code
MAT021	514.0368320	
113608	0	
116308	5.01556842	
117285	67.544	
119331	44.2	
119802	5.94	
120218	17.26	
120866	64.8126316	
121805	309.264632	

MS21059L3		Purchased	No			170	Each	269.0000	2	24			
-----------	--	-----------	----	--	--	-----	------	----------	---	----	--	--	--

MS21059L 3

Nut Plate

**

Sp 107/24

Location	Loc Qty	Loc Code
302	25	
121185	25	
ST301	28	
118614	8	
119546	20	
ST302	216	
106042	2	
120308	13	
120833	1	
121444	100	
121524	100	

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

June-27-12 3:20:48 PM

Page 2

Work Order ID: 86347

Parent Item: D3948-041

Parent Item Name: Plate, Anchor

86347

D3948-041

Start Date: 27/06/2012

Required Date: 11/07/2012

Start Qty: 12.00

Required Qty: 12.00

MS20426AD3-3

Purchased

No

170

Each

2,987.000

4

48

MS20426AD3-3

Rivet

**

EP 12/07/24
48

Location

Loc Qty

Loc Code

ST316

2987

119109

537

121011

2033

19099

417

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

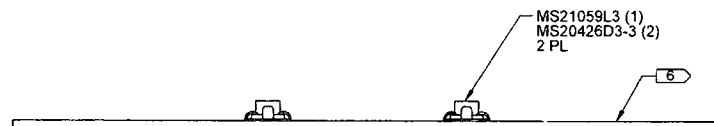
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

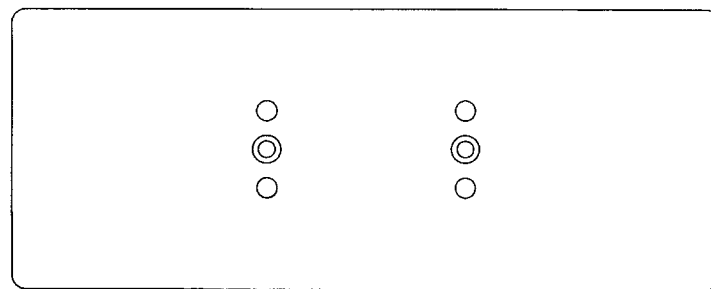
NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-041	PLATE, ANCHOR
2	1	D3948-1	PLATE
3	2	MS21059L3	NUTPLATE (OR MS21059-3)
4	4	MS20426AD3-3	RIVET



MS21059L3 (1)
MS20426D3-3 (2)
2 PL

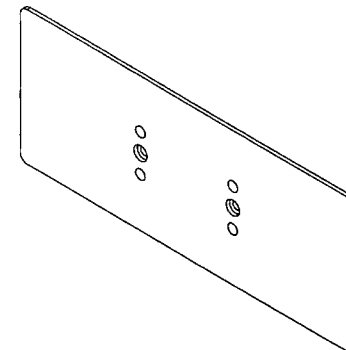


D3948-1

D3948-041 PLATE, ANCHOR

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.10 lbs



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 86347 M.L.J.
12/06/28

RELEASED
09/06/18

B	-3F NOW MADE FROM 304 SS (ZN A8-5), 0.063 THICK WAS 0.040 (ZN A8-3, A8-5), -043/-3/-3F WIDER (ZN B6-4, B6-5)	CP	09.06.08
A	NEWISSUE	CP	09.05.13
REV.	DESCRIPTION	BY	DATE
DESIGN	921		
DRAWN	921		
CHECKED	921		
MFG APPR.	921		
APPROVED	921		
DE APPR.	921		
DATE	09.06.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3948 TITLE PLATE, ANCHOR REV. B SHEET 1 OF 5 SCALE NTS <small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

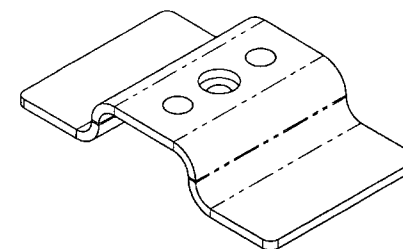
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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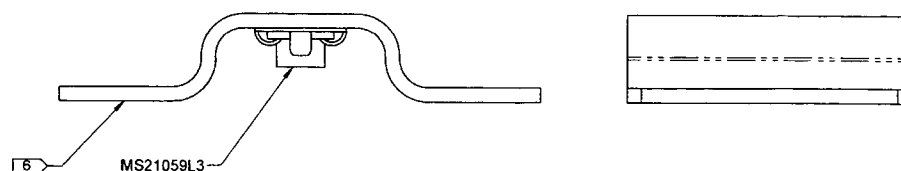
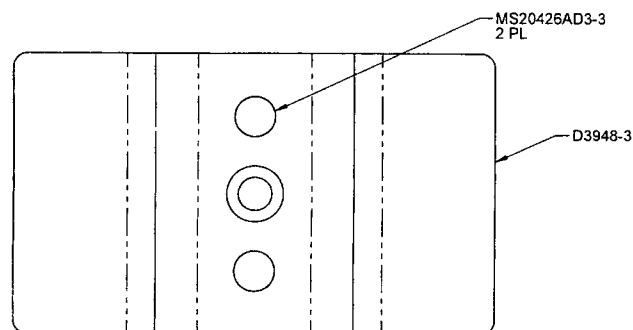
NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3948-043	PLATE, ANCHOR
2	1	D3948-3	PLATE
3	1	MS21059L3	NUTPLATE (OR MS21059-3)
4	2	MS20426AD3-3	RIVET



86347

**D3948-043 PLATE, ANCHOR**

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3948-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.06 lbs

RELEASED

DESIGN	DP	DART AEROSPACE LTD	
DRAWN	DP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	DP	DRAWING NO.	REV. B
MFG. APPR.	DP	D3948	SHEET 2 OF 5
APPROVED	DP	TITLE	SCALE
DE APPR.	DP	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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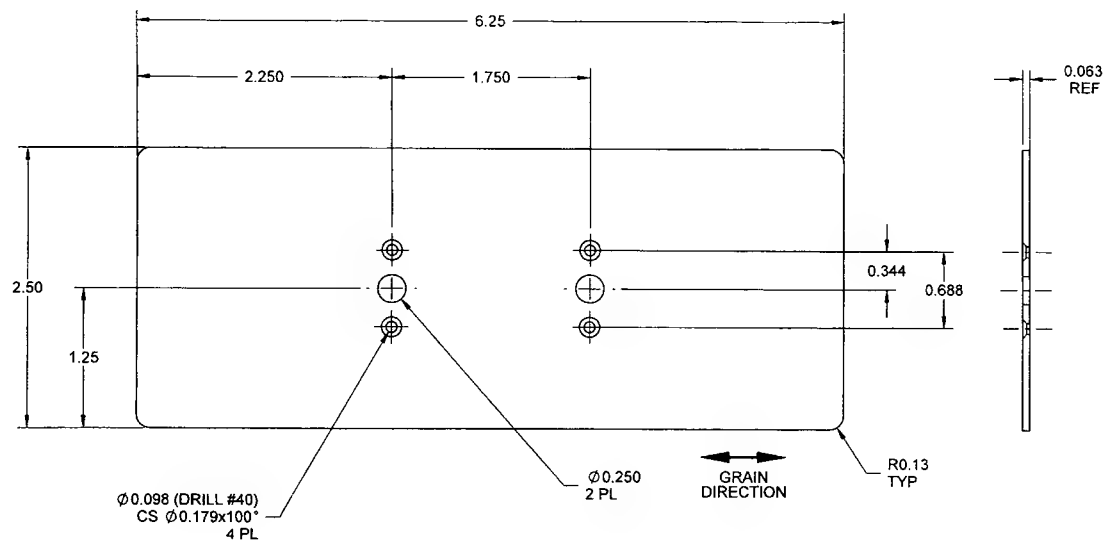
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3948-1 PLATE

RELEASED
09/06/08

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063" THICK PER AMS-QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN	97	DART AEROSPACE LTD	
DRAWN	97	HAWKESBURY, ONTARIO, CANADA	
CHECKED	97	DRAWING NO.	REV. B
MFG. APPR.	97	D3948	SHEET 3 OF 5
APPROVED	97	TITLE	SCALE
DE APPR.	97	PLATE, ANCHOR	NTS
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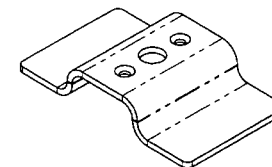
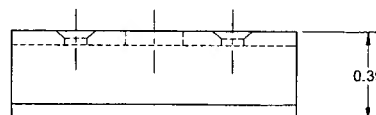
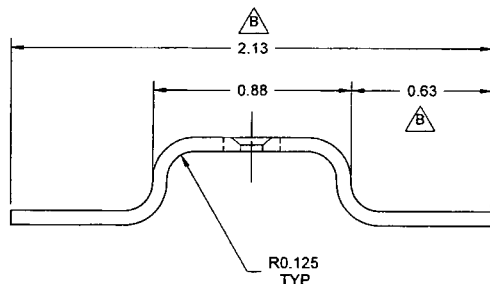
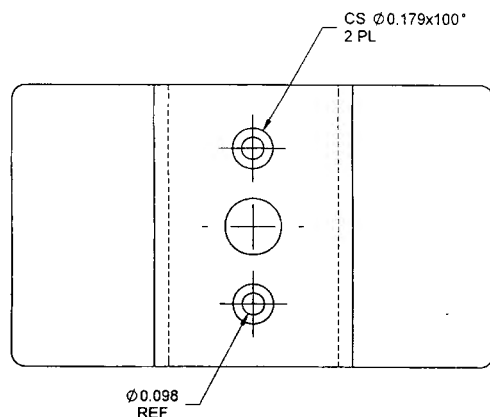
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



86347

D3948-3 PLATE

NOTES:

- 1) MATERIAL: MAKE FROM D3948-3F
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.06 lbs

RELEASED
9/25/16

DESIGN	<i>99</i>	DART AEROSPACE LTD	
DRAWN	<i>99</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>99</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>99</i>	D3948	SHEET 4 OF 5
APPROVED	<i>99</i>	TITLE	SCALE
DE APPR.	<i>99</i>	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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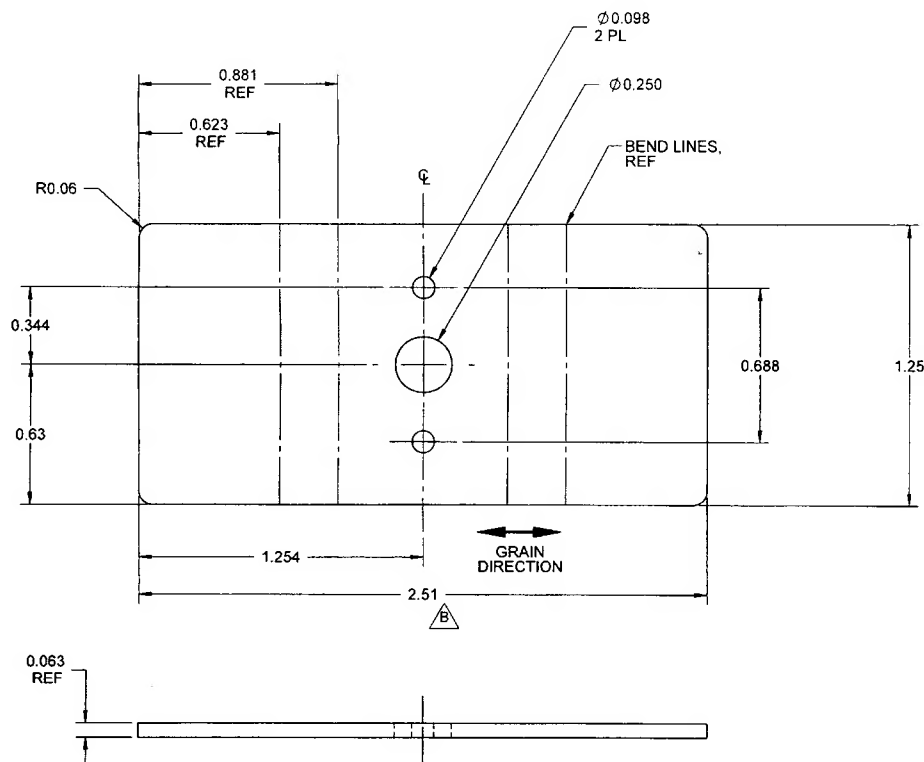
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

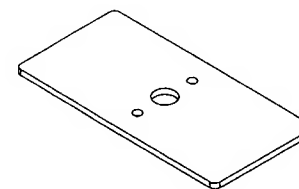
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3948-3F PLATE



86347

RELEASED
07/06/16

- NOTES:**
- 1) MATERIAL: AISI 304 SS SHEET 0.063" THICK (REF DART SPEC. M304S.063)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.06 lbs

DESIGN	<i>g</i>	DART AEROSPACE LTD	
DRAWN	<i>g</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>g</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>g</i>	D3948	SHEET 5 OF 5
APPROVED	<i>g</i>	TITLE	SCALE
DE APPR.	<i>g</i>	PLATE, ANCHOR	NTS
DATE	09.06.08	COPYRIGHT © 2009 BY DART AEROSPACE LTD	
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries